

WELDER QUALIFICATION TECHNIQUE SHEET (SAMPLE)**PROCESS:** _____**WQT No.:** _____ **REVISION No.:** _____ **DATE:** _____ **M/HR:** _____**SUPPORTING WPS (s):** 1. _____ 2. _____ 3. _____**MATERIAL:** _____ to _____ **P No.:** _____ to _____**JOINT THICKNESS:** _____ to _____ **DIAMETER/SIZE:** _____ **JOINT TYPE:** _____**PREPARATION:** _____**BACKING:** _____ **BACKING GAS FLOW RATE:** _____ **CFH****SHIELDING GAS:** * or _____ **FLOW RATE:** _____ **CFH****WELDING POSITION:** _____ **W or S BEAD:** _____ **PROGRESSION:** _____**BRAZING POSITION:** _____ **TECHNIQUE:** _____ **FLAME ADJ:** _____**PH: °F MIN** _____ **IPT: °F MAX** _____ **FUEL GAS:** _____ **CURRENT:** _____**BRAZING TEMP. RANGE:** _____ °F to _____ °F **TEST TYPE:** _____

*See appropriate WPS for gas mixture

JOINT SKETCH**INSTRUCTIONS**

1. Grind bevel edge to approximately 1/32 inch or less.
2. Perform fitup and tack weld coupons.
3. Contact Weld Test Supervisor for approval.
4. Complete root and notify Weld Test Supervisor for visual inspection.
5. Complete welding including cap and notify Weld Test Supervisor for final visual inspection and instruction on specimen removal.

FILLER METAL	SIZE	AMPS RANGE	VOLTS RANGE	GUN ANGLE°
				to
				to
				to
				to
				to

Above passes/layers are representative only, more or less may be required. Note: Inter-pass cleaning shall be performed using a file, wire brush, or chipping hammer only. Grinders are permitted only for feathering of tacks or with the inspector's approval. Grinding the cover pass is not allowed unless directed by the Weld Test Supervisor. Welding repairs are not allowed.

AUTHORIZED BY_____
DATE